

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012022**Date Inspected:** 11-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Chi Chang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Trial Assembly Area

This QA Inspector observed the following work in progress:

FCAW in the 3G position for the OBG Segment 7AW to 7BW, weld No.BP035-001-38. The welder is identified as #066746. ZPMC QC is identified as Mr. Li Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2233-B-U2-F.

SMAW in the 1G position for the OBG Segment 5CE, weld No.SEG026A-008. The welder is identified as #066179. ZPMC QC is identified as Mr. Yang Qong. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1. The weld repair report is identified as B-CWR-1201.

Heat Straightening

During in process inspection the QA Inspector observed that the ZPMC personal doing heat straightening on butt weld joint joining at Segment 5CE side plate SP306A to SP425A bike path side .The weld joint is identified as SEG026A-010 . And the heat straightening report identified as HSR(B)-353.

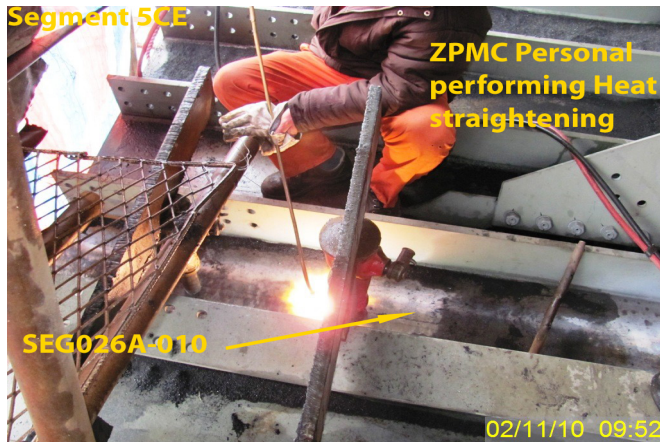
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After Blast Inspection

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 7DW internal side panel, bottom panel, floor beam and longitudinal diaphragms surfaces from the panel point 56 to 57 after grit blasting. Areas that marked for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
